



Dart Hawkesbury
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D2214
Job Sheet 167802



Part No: D2214

Job Qty: 1 ea

Part Name: Window, Inside



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Rotorcraft Support Inc (CROTO01)

16425 Hart Street Van Nuys, CA, 91406 USA ph:(818) 997-7667 fx:(818) 997-1513.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/17/17	11/17/17	0.00	0.00	Start up container		
100	Waterjet	1 pcs	11/17/17	11/17/17	0.00	0.00	Waterjet1		
110	QC	1 pcs	11/17/17	11/17/17	0.00	0.00	QC2		
120	QC	1 pcs	11/17/17	11/17/17	0.00	0.00	QC8		
130	Small Fab	1 pcs	11/17/17	11/17/17	0.00	0.00	Small Fab		
140	QC	1 pcs	11/17/17	11/17/17	0.00	0.00	QC5		
150	Small Fab	1 pcs	11/17/17	11/17/17	0.00	0.00	Small Fab		
160	Packaging	1 pcs	11/17/17	11/17/17	0.00	0.00	Packaging3		
170	QC21-SA	1 Ea	11/17/17	11/17/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D2214 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 130 - 1-Cut D2462 Seal to length and Install around edge 2-Transfer holes through seal 3-Attach small DART logo labels

D2728-1as per template DT 8223

150 - Wrap window in celophane wrap

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MACRLICS.125	1	2,397	0	0
130-Small Fab	D2462	4	278	0	0
	D2728-1	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:14 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____	Step #: _____	QTY Effective : _____		RB (QSI042) Approval _____		

Description Work Order Deviation

Job No: 167802
Mfg Date: 11/20/17

Start up Operation

D2214

Change No: _____
Operation: _____
Revision: _____
PART NO: _____

Completed By _____

Hand / Supervisor _____
Approval _____

QA Coordinator Approval _____

Wrong Dimensions _____
Under tolerance _____

Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Fo ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ri ☐
Material ☐	Use for Testing ☐	Cuffs ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : _____

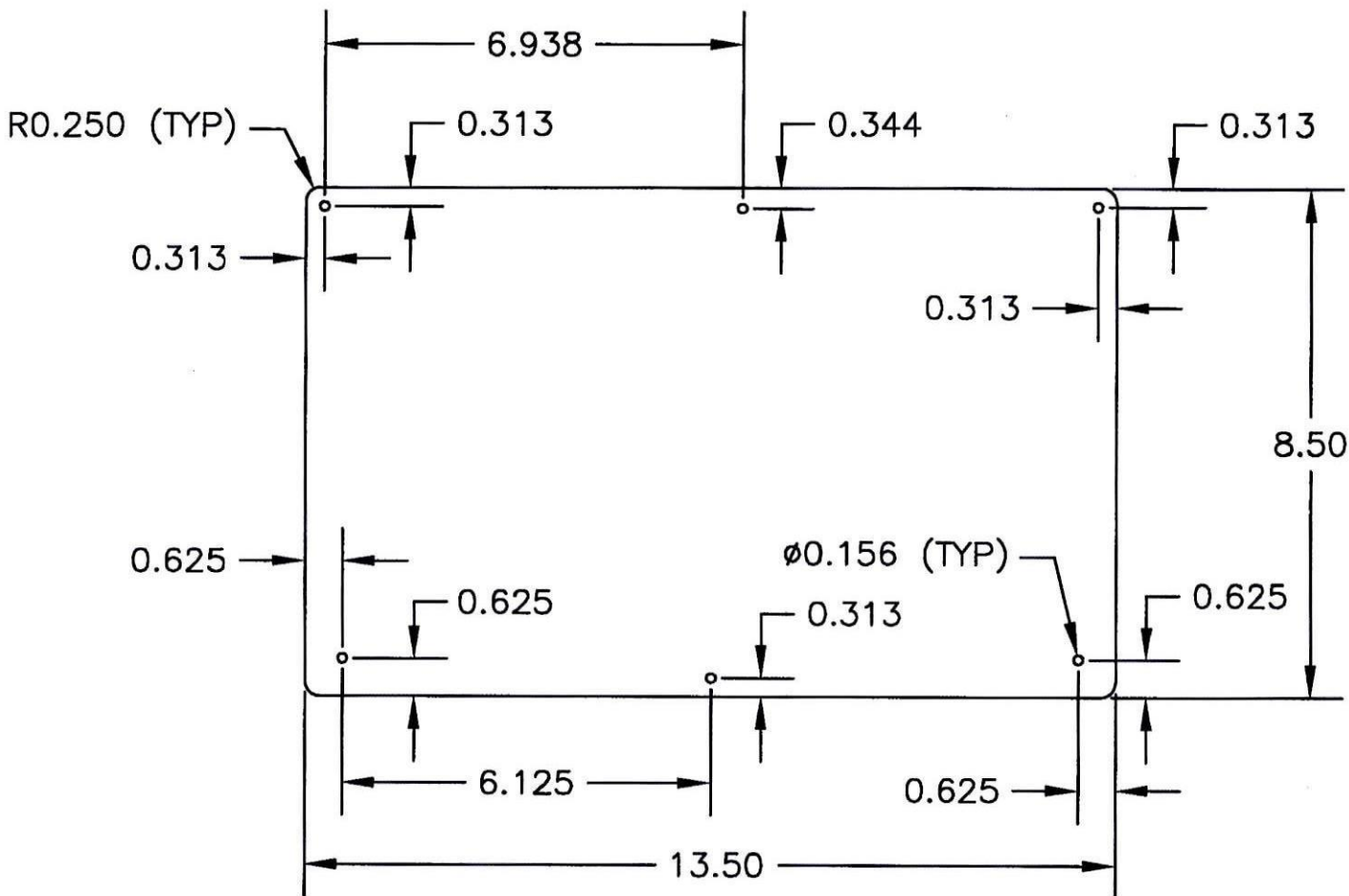
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Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incomplete/Unclear ☐
Drill Holes ☐

Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set ☐
Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

DART

DESIGN	BW	DRAWN BY	SSH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV/C
				D2214	SHEET 1 OF 1
DATE				TITLE	SCALE
06.04.13				WINDOW	1:3
A		94.02.09	NEW ISSUE		
B		99.03.10	UPDATE DIMENSION AND TEMPLATE		
C		06.04.13	UPDATE MATERIAL PER NCR 029		



D2214 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) MANUFACTURE FROM TEMPLATE DT8223 (DIMENSIONS ARE FOR REF. ONLY)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES